

Work Order ID 83827

83827

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Thursday, April 26, 2012 1:07:54 PM

Item ID: D4462-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2*** 2
 Item Name: Baffle
 Start Date: 4/26/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/3/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MUF Date: 12-04-26 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | (6) | | | |
| D4462 | B | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | B12-4-07 |
| FLOW CNC Waterjet | Cut as per dwg | | | | | | | | |
| 6061 .050 | Prog rev: <u>B</u> | | | | | | | | |
| | Dwg rev: <u>B</u> | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | B12-4-07 |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | Schultz |
| Quality Control | | | | | | (46) | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Thursday, April 26, 2012 1:07:54 PM

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Page 2

Item ID: D4462-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Baffle

Start Date: 4/26/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

SB 12/04/30

FF 12/04/30

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

Quality Control

Schulz

(x6)

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

(6) HG 12-4-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 26, 2012 1:07:54 PM

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Work Order ID: 83827

Parent Item: D4462-1

Parent Item Name: Baffle

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|----------------|----------------|--------|
| M6061T6S.050 6061-T6 .050 Sheet | | Purchased | No | | | 100 | sf | 245.6640 | 2.138 | 9.0021053 | B ₁ | | |

B12-21-37

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| 021 | 144 | |
| 1211920 | 144 | |
| MAT021 | 101.664 | |
| 113216 | 10 | |
| 114799 | 76.664 | |
| 114993 | 15 | |

~~112766~~
114799

6

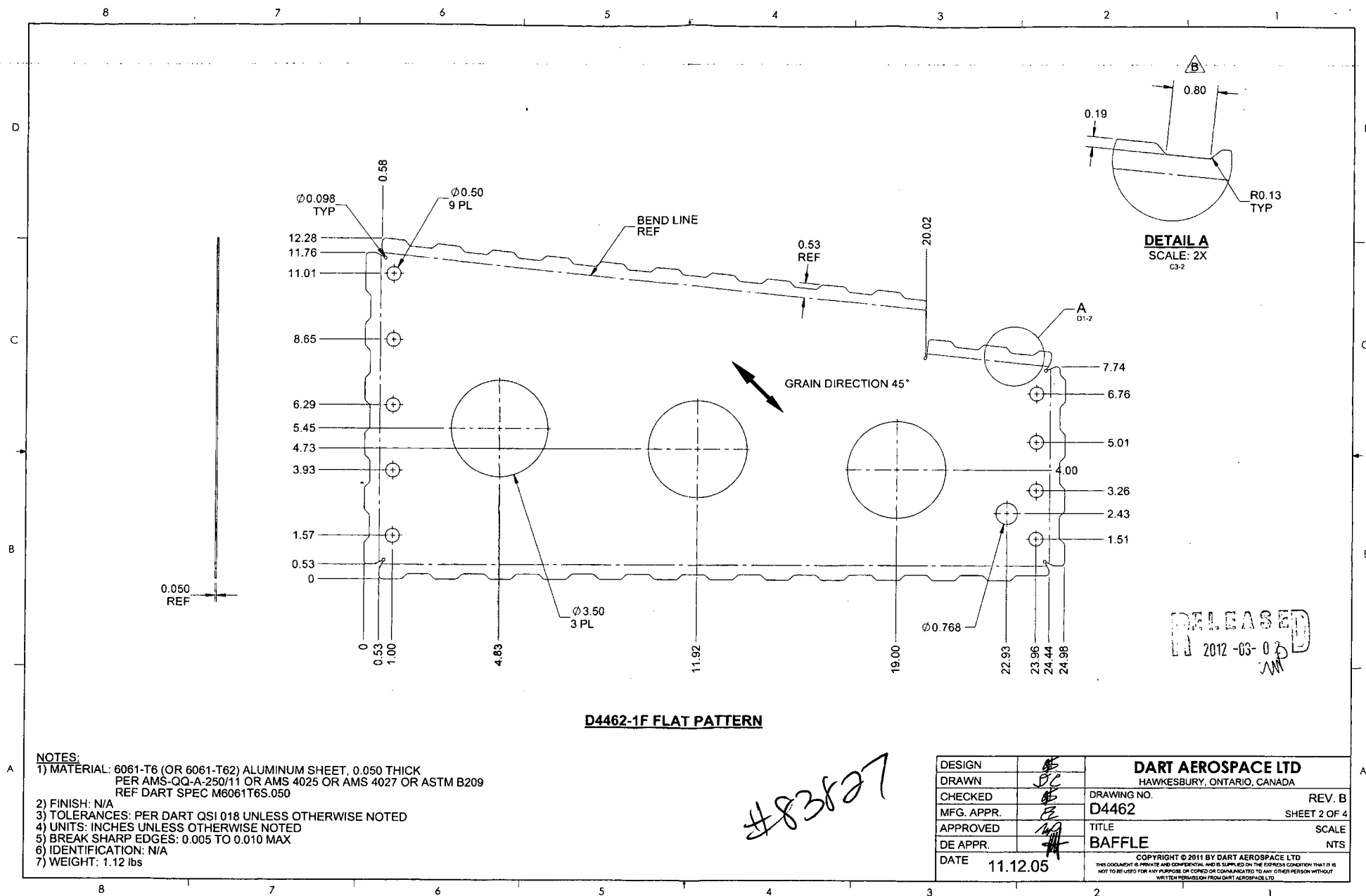
| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



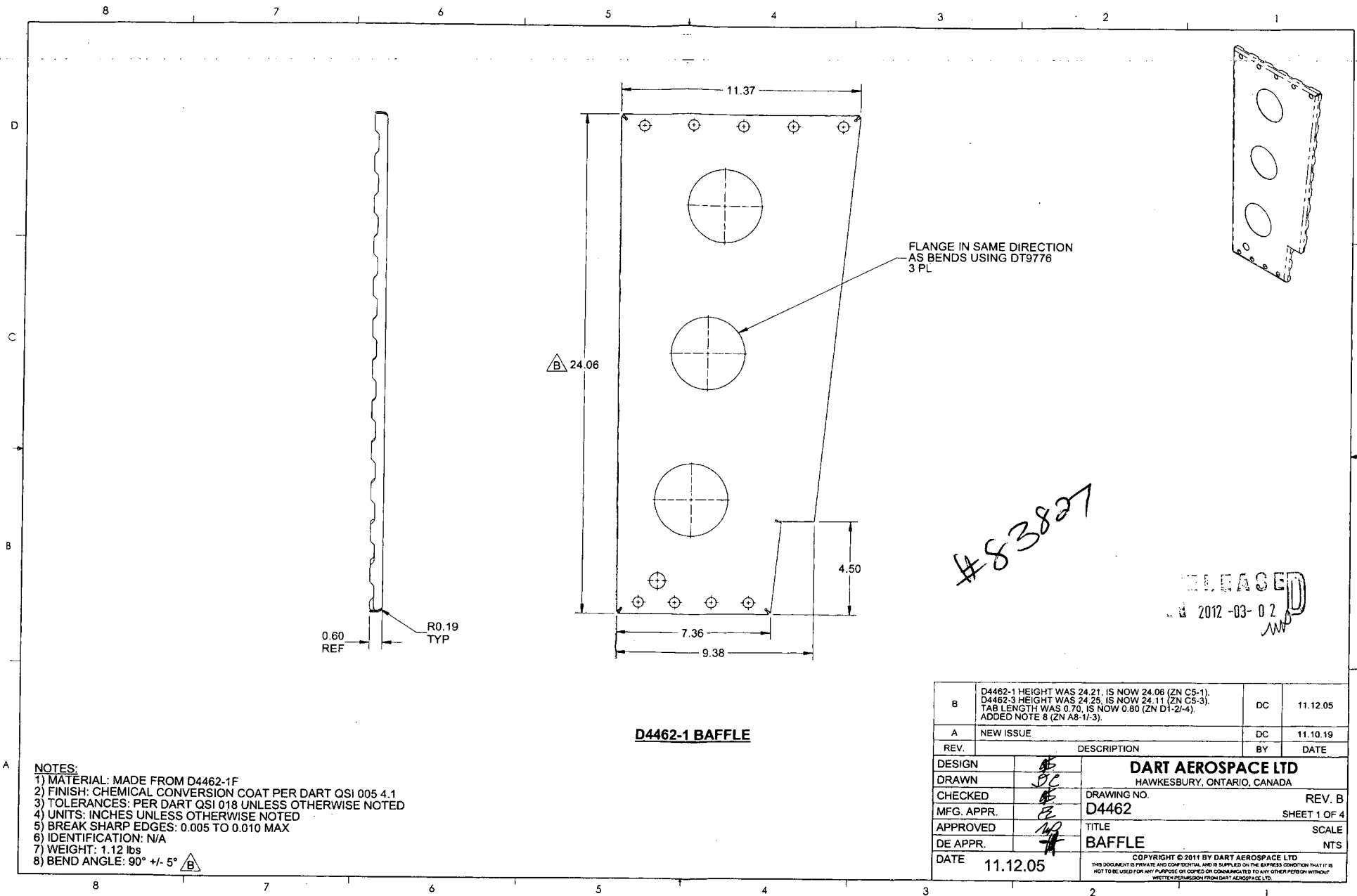
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NOTE: Date & initial all entries



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NOTE: Date & initial all entries

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|-------------------------|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 83827 |
| Description: BAME | | Part Number: D4462-1 |
| Inspection Dwg: D4462-1 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 50 | +0.006 - .001 | 50.4 | ✓ | | ✓ H802 | |
| 768 | +0.010 - .001 | 770 | ✓ | | ✓ | |
| .53 | ± .030 | .540 | 2 | | ✓ | |
| 1.00 | ± .030 | 1.002 | 2 | | ✓ | |
| 4.83 | ± .030 | 4.833 | 2 | | ✓ | |
| 11.93 | ± .030 | 11.93 | 2 | | ✓ | |
| 19.00 | ± .030 | 19.00 | 2 | | ✓ | |
| 22.93 | ± .030 | 22.93 | 2 | | ✓ | |
| 23.96 | ± .030 | 23.96 | 2 | | ✓ | |
| 24.44 | ± .030 | 24.44 | 2 | | ✓ | |
| 24.98 | ± .030 | 24.98 | 2 | | ✓ | |
| 20.02 | ± .030 | 20.02 | 2 | | ✓ | |
| .53 | ± .030 | .533 | 2 | | ✓ | |
| 1.57 | ± .030 | 1.570 | 2 | | ✓ | |
| 3.93 | ± .030 | 3.927 | 2 | | ✓ | |
| 4.73 | ± .030 | 4.725 | 2 | | ✓ | |
| 5.45 | ± .030 | 5.456 | 2 | | ✓ | |
| 6.24 | ± .030 | 6.293 | 2 | | ✓ | |
| 8.65 | ± .030 | 8.653 | 2 | | ✓ | |
| 11.01 | ± .030 | 11.013 | 2 | | ✓ | |
| 11.76 | ± .030 | 11.757 | 2 | | ✓ | |
| 12.28 | ± .030 | 12.28 | 2 | | ✓ | |
| 1.51 | ± .030 | 1.511 | 2 | | ✓ | |

| | | |
|----------------|---------------|---------------------|
| Measured by: B | Audited by: S | Prototype Approval: |
| Date: 12-4-27 | Date: 12/4/27 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

